

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/Ala Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018696**Date Inspected:** 01-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA Inspector) George Goulet was present during the times noted above for observations relative to the work being performed.

OBG Trial Assembly Area

This QA Inspector randomly observed the following work in progress in the OBG Trial Assembly Area:

ZPMC personnel match drilling into web plate of PCMK OBG 11DE (FL3 area)/CB16, panel point 106 at previously scored pilot holes, using magnetically-held drill presses.

ZPMC CWI Zhu Zhong Hai and ABF Representative Cao Hai Zhou informed this QA Inspector that no welding work was being performed during this night shift. This QA Inspector observed no welding operation in progress.

ZPMC workers performing what appeared to be final tightening of ASTM A325M bolt sets on deck plate U-rib/splice plate connections at the 11AE/11BE transverse joint using an air impact gun. See photo below. Each bolt set observed appeared to have been marked at the snug-tight phase of tightening in conformance with contract documents.

Bay 14

This QA Inspector randomly observed the following in Bay 14:

FCAW repair welding of weld joint SEG3007L-046 located on PCMK OBG 13AE, panel point 118.8. Welder

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was identified as 066733. QC was identified as ABF CWI Bao Qian (QC1). Welding variables recorded by QC1 appeared to comply with WPS-B-T-2233-ESAB as verbally identified by QC1.

FCAW repair welding of weld joint SEG3007J-048 located on PCMK OBG 13AE, panel point 118.8. Welder was identified as 066763. QC was identified as QC1. Welding variables recorded by QC1 appeared to comply with WPS-B-T-2233-ESAB as verbally identified by QC1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

As noted above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Goulet, George
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Quality Assurance Inspector

Reviewed By:	Carreon, Albert
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QA Reviewer
